

Work Order ID 137538

October 05, 2015 11:45:05 AM

137538

Page 1

Item ID: D3188-2M Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacepod Body RH
Start Date: 10/5/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/19/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: SH Date: 20151005 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3188	G

100 PURCHASING 0.00

100

Purchasing

Purchasing

Memo

Issue P/O: 31394

Description: D3188-2P BODY

SHIP: QTY (8) D2213 Spacers

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 2 Items from Previous steps

CL FEB 17 2016
OCT 06 2015 1

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

IX SP/6-6-29
IX U 1609.19
IX SP/6-10-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER :							

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Page 2

Item ID: D3188-2M Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Spacepod Body RH
Start Date: 10/5/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/19/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS 16 9-89
120									
QC	Memo	0.00							10/10/12
Quality Control	Check for void spot and pins.								
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							5 10/10/13
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							DAS 21 9-89
Quality Control									OCT 13 2016

DAS
21
9-89

OCT 13 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
25-01-1 25-01-1 25-01-1				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

October 05, 2015 11:45:11 AM

Page 1

Work Order ID: 137538

137538

Parent Item: D3188-2M

D3188-2M

Parent Item Name: Spacepod Body RH

Start Date: 10/5/2015

Required Date: 10/19/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New issue ecn882 06-11-30 EC
IPP rev B rev D dwg 07.03.07 ec
IPP rev C rev E dwg 07.04.16 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2213 *D2213* Insert		Manufactured	No			100	Each	50.0000	8	8			
									**				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST004		50							
					30809	50							
D3188-2P *D3188-2P* Spacepod Body		Purchased	No			110	Each	0.0000	1	1			
									**				

CX15/10/08 delisted
CY16/02/22 FDC

~~1X SP/16-6-29~~
KSP/16-10-12

GENERAL NOTES:

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-38/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A
D3188-2 = N/A
D3188-3 = N/A
D3188-5 = N/A
D3188-6 = N/A
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

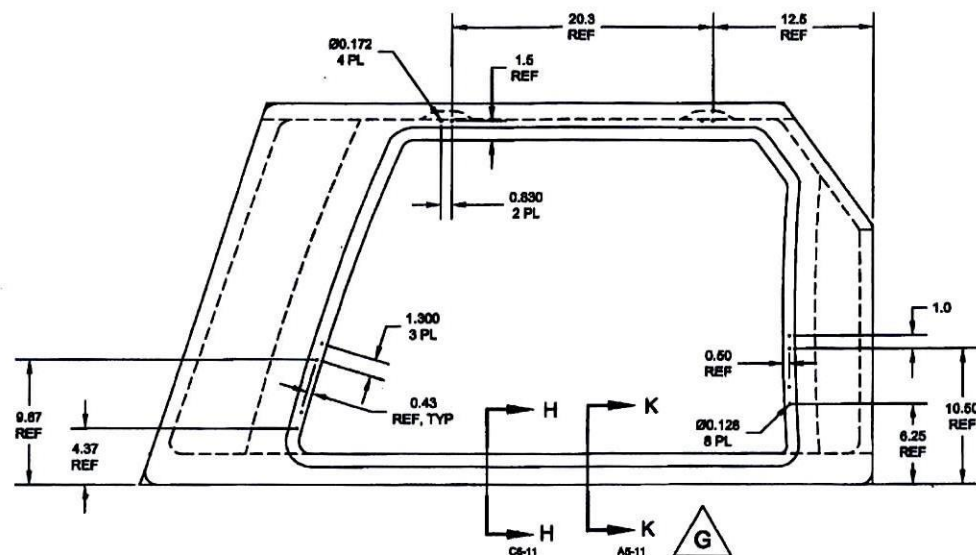
10) POT INSERTS PER QSI 006 SECTION 4.16

20151005

20151005 SH 137538

RELEASED
2014-07-28

G	ADD SECTION K-K/L-L: INSERT INSTALLATION TO SHEET 11 (ZN A5-11)	DB	14.08.20
F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0800-XXX LABELS	LE	08.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	08.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JB	DRAWING NO.	REV. G
MFG. APPR.	JB	D3188	SHEET 1 OF 11
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	SPACEPOD BODY	NTS
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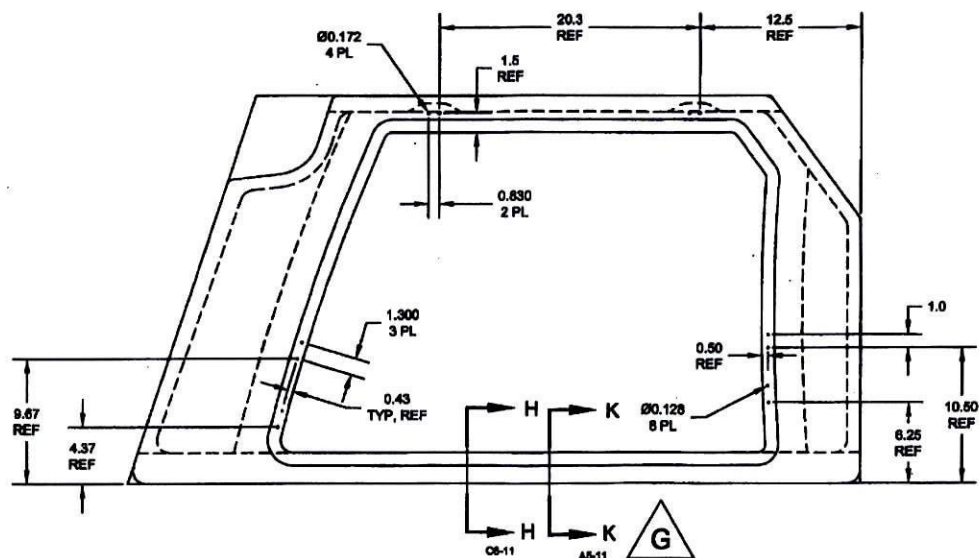
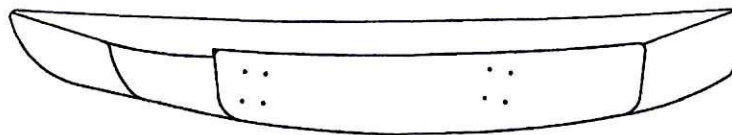
D3188-1 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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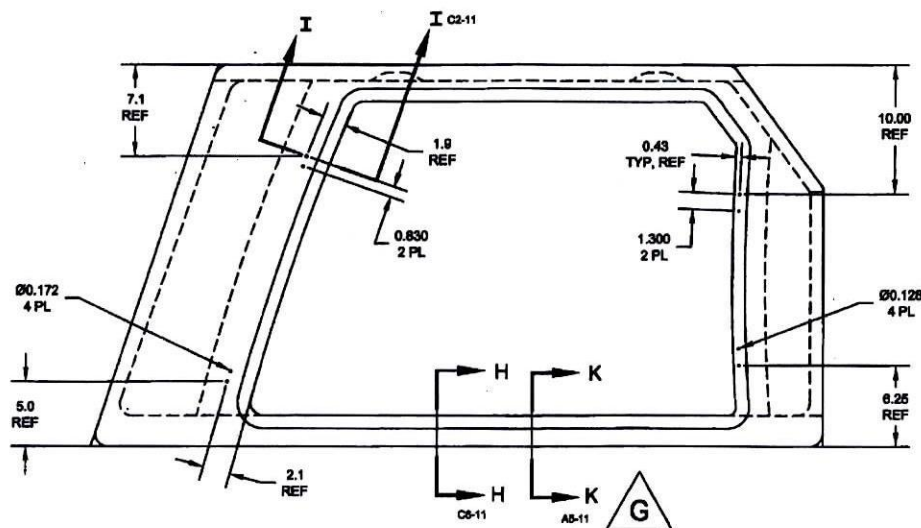
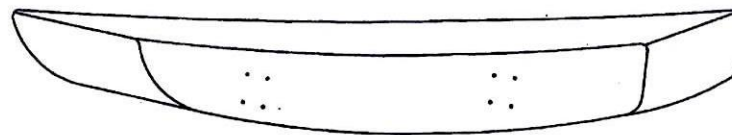
D3188-3 SPACEPOD BODY
MAKE FROM D3188-3M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 4 OF 11
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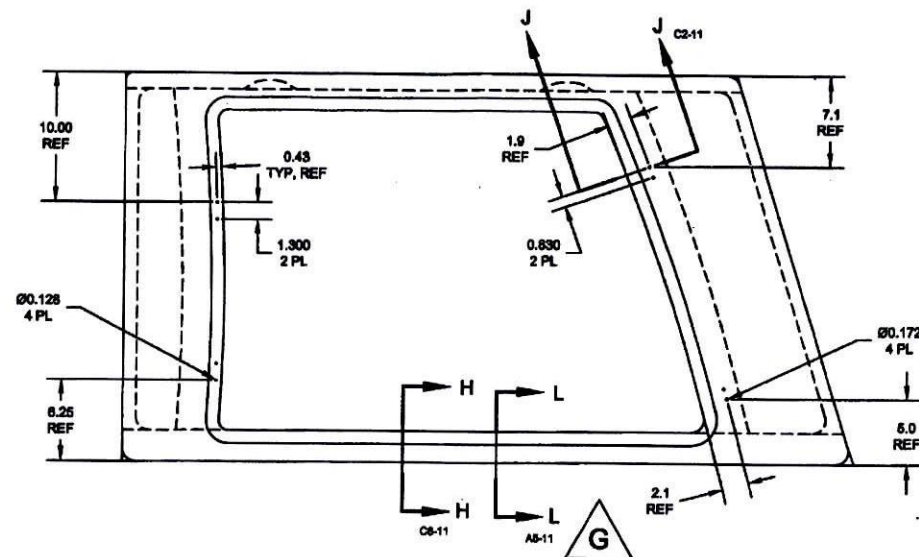
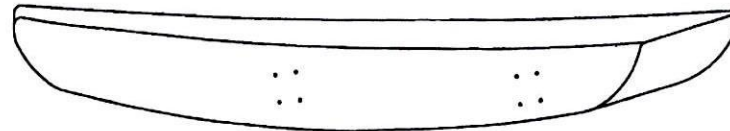
D3188-5 SPACEPOD BODY
MAKE FROM D3188-1M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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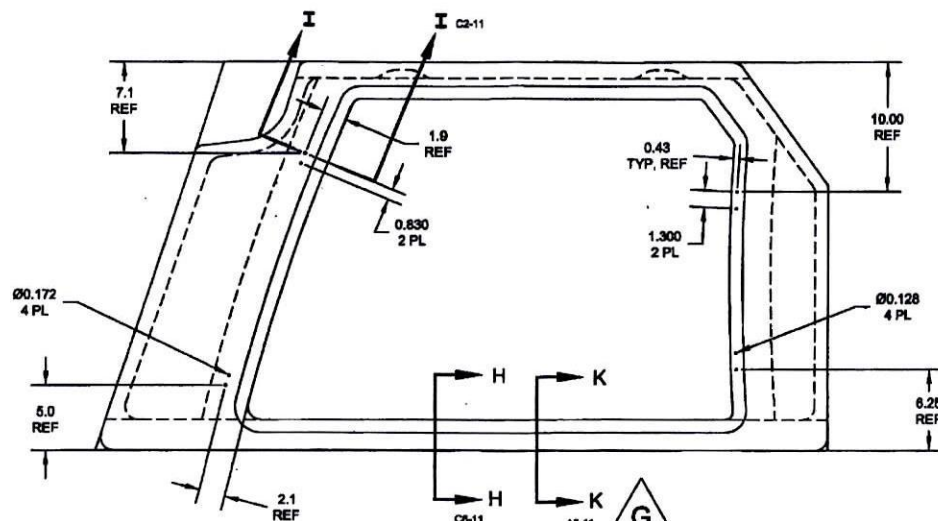
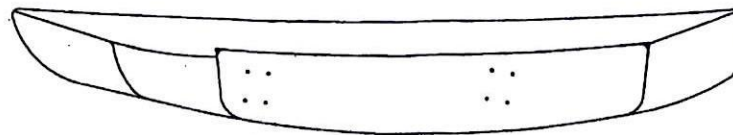
D3188-6 SPACEPOD BODY
MAKE FROM D3188-2M

NOTES:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

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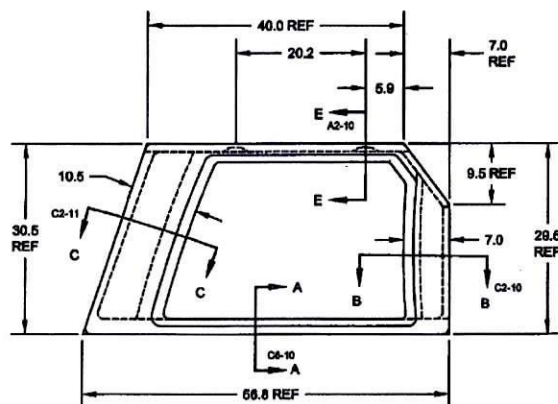
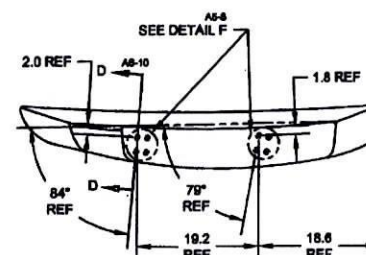
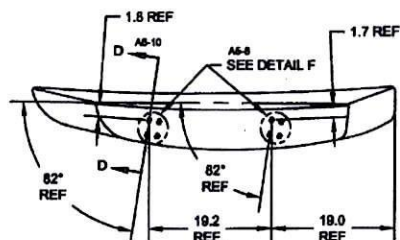
D3188-7 SPACEPOD BODY
MAKE FROM D3188-3M

RELEASED
2014-07-28
JW

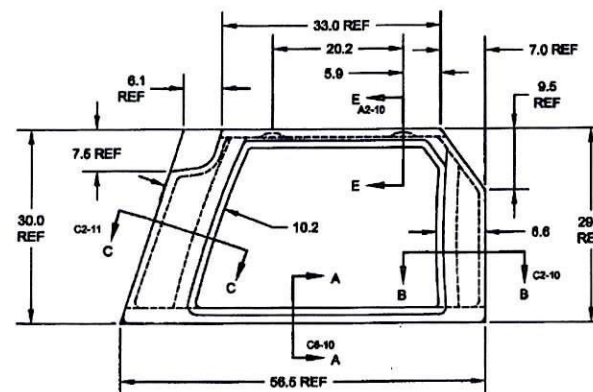
NOTE:

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3188-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

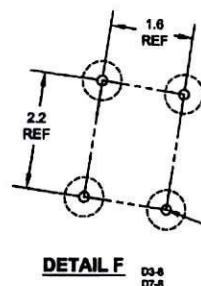
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D3188-1M SPACEPOD BODY



D3188-3M SPACEPOD BODY

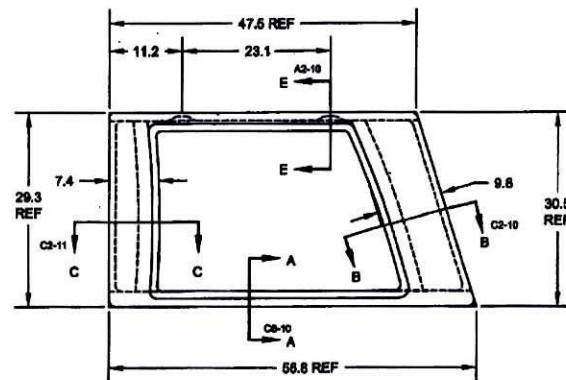
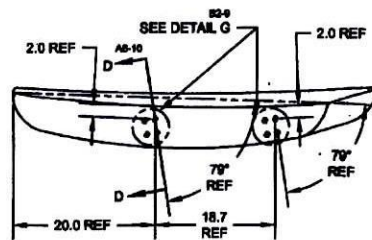


INSTALL
D2213 SPACER
8 PL
SEE SECTION D-D
A6-10

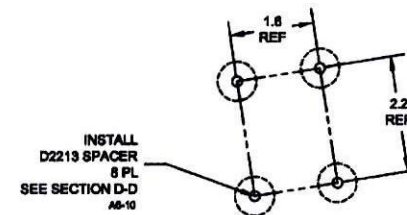
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- D3188-1M/-3M NOTES:**
1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2) SEE SHEET #10 FOR SECTION VIEWS.

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D3186-2M SPACEPOD BODY



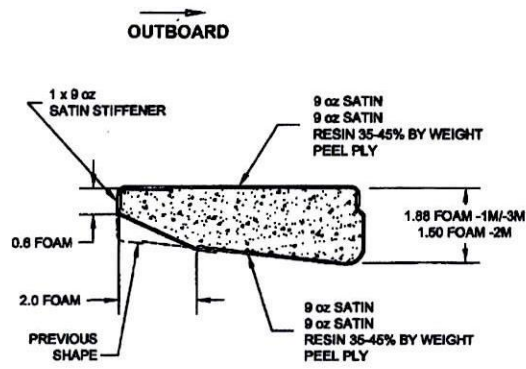
DETAIL G D6-9

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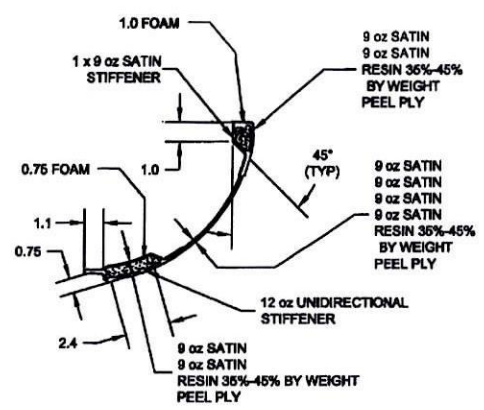
D3186-2M NOTES:

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

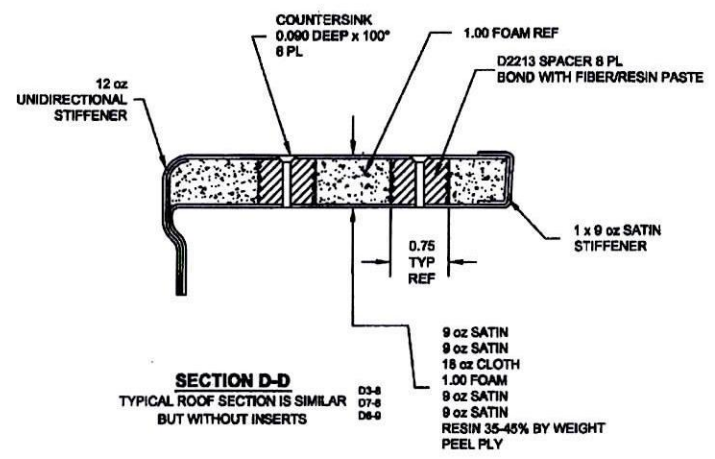
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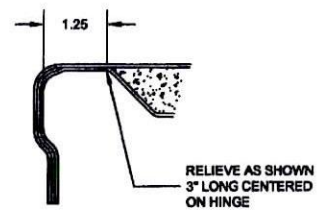
SECTION A-A
TYPICAL FLOOR SECTION



SECTION B-B
SECTION C-C OPPOSITE



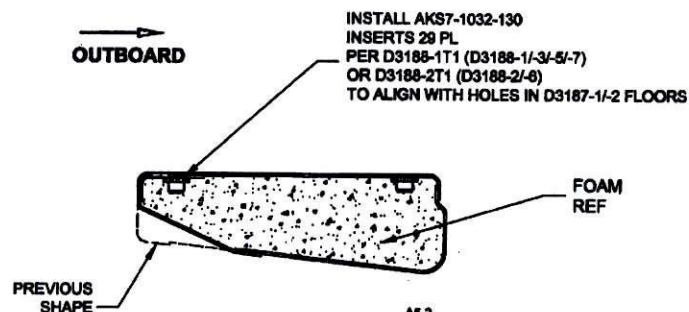
SECTION D-D
TYPICAL ROOF SECTION IS SIMILAR
BUT WITHOUT INSERTS



SECTION E-E
2 PLACES PER POD

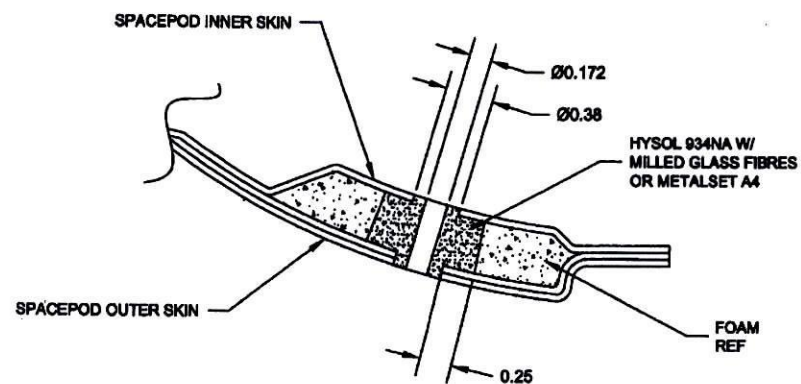
RELEASED
2014-07-28

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3188	REV. G
MFG. APPR.			SHEET 10 OF 11
APPROVED		TITLE SPACEPOD BODY	SCALE NTS
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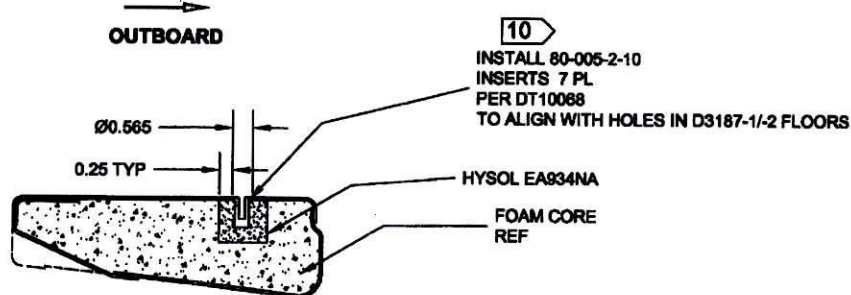
SECTION H-H
TYPICAL FLOOR SECTION

A5-2
A5-3
A5-4
A5-5
B5-6
B5-7



SECTION I-I
SECTION J-J OPPOSITE
4 PLACES PER POD

C5-6
C4-6
C5-7



SECTION K-K
SECTION L-L OPPOSITE
TYPICAL FLOOR SECTION

B4-2
B5-3
B4-4
B4-5
B4-6
B4-7

RELEASE
2014-07-28

DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3188	SHEET 11 OF 11
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD BODY	NTS
DATE	14.06.20	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

Purchase Order ID PO31394

Purchase Order Date 2/17/2016
PO Print Date 2/17/2016

Page Number 1 of 3

Order From :

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

VC-FDC01

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
FEB 19 2016

Contact Name
Vendor Phone 450-357-1344 ext303

Ship To Contact
Ship To Phone
Ship Via:
Ship Acct:

Buyer
Customer POID
Customer Tax #
Terms
Currency
FOB
Chantal Lavoie
10127-2607
Net 30
CAD
Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3188-2P AS PER DWG D3188 REV.G B141769	Spacepod Body	3/31/2016 Yes 3/31/2016		1.00 Each	\$2,460.00	\$2,460.00
SP16-6-29						Line Total:	\$2,460.00
2	D3186-2P AS PER DWG D3186 REV.E B135276	Spacepod Door	3/31/2016 Yes 3/31/2016		1.00 Each	\$810.00	\$810.00
SP16-04-18						Line Total:	\$810.00
3	D3188-2P AS PER DWG D3188 REV.G B137538	Spacepod Body	7/27/2016 Yes 7/27/2016		1.00 Each	\$2,460.00	\$2,460.00
SP16-6-29							

Note:

2/17/2016

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tél. : 450 357-1344

Bon de livraison

25/05/2016

Commande : 2452
Référence : PO #31394/3

Client : Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Expédier à

DART AEROSPACE LTD
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7
Tél.: 1 613 632-9577

No item	Description	Qté	Qté livrée	Qté B/O
D3188-2P	Spacepod Body PO item: 31394/3 Lot: 2016-04-20 B137538	1		

CANADIAN CURRENCY

Sp/6 b-29

Transport :

Réf. :

Nb colis :

Marchandise reçue :



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CERTIFICATE of CONFORMITY

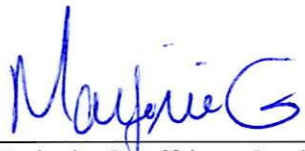
Customer Name: Dart Aerospace.

Customer P/O Number: 31394

<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number Part</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
3	1	D3188-2P Spacepod Body	D3188 Rev.G	B137538	DAE014-002	2016-04-20

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature:


Marjorie Geoffrion, Quality Manager

Date:

2016-05-24



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31394**

Purchase Order Date 2/17/2016

PO Print Date 10/4/2016

Page Number 2 of 4

Order From : VC-FDC01
FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450-357-1344 ext303

Ship To Contact
Ship To Phone
Ship Via: —
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

3	D3188-2P	Spacepod Body ✓	7/27/2016 Yes 7/27/2016	1.00 Each	\$2,460.00	\$2,460.00
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AS PER DWG D3188 REV.G
B137538

D3188-2P

10/4/2016

10/12/2016

PRICE FOR REWORK PER QUOTE 1356
REQUIRE REWORKED BODY AND DOOR ON OR BEFORE OCT 12

SP/6-10-12

Line Total: \$5,140.00

4	D3186-2P	Spacepod Door	4/8/2016 Yes 4/7/2016	1.00 Each	\$810.00	\$810.00
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AS PER DWG D3186 REV.E
B137539

Line Total: \$810.00

Note:

10/4/2016

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5 Tel.: 450 357-1344

Shipping Order

12/10/2016

Order : 2538
Reference : PO #31394/8

Customer: Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Ship To

DART AEROSPACE LTD
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7 Tel.: 1 613 632-9577

Item No.	Description	Qty	Qty. Delivered	B/O Qty
D3186-2P ✓	Spacepod Door PO item: 31394/8 FDC ID: DAE013-003 Lot: 2016-03-29	1 ✓	_____	_____
D3188-2P ✓	Spacepod Body PO item: 31394/8 FDC ID: DAE014-003 Lot: 2016-05-09 PRICE FOR PART D3188-2P IS INCLUDED IN PRICE FOR PART D3186-2P PARTS WERE GIVEN TO ERIC DOWNING FOR RETURN TO DART AEROSPACE	1 ✓	_____	_____

8/16-10-12

Shipping : _____
Package No : _____
Merchandise Received: _____

Ref. : _____

CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 31394

Revision: N/A

PO Item	Qty	Part number	Description	Dwg number Part	FDC ID	Lot
8	1	TBD	D3186-2 Side Door Repair	D3186 Rev.E	DAE013-003	2016-03-29
8	1 ✓	TBD	D3188-2 Spacepod Body Repair	D3188 Rev.G	DAE014-003	2016-05-09 ✓

Modified as per Dart's special instruction

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: 
Karim Malihy, B Eng, Quality Manager

Date: 12 Oct 2016